

Work Order ID 79210

79210

Page 1

Monday, January 23, 2012 3:26:16 PM

Item ID: D206-667-201

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Crosstube Aft

Start Date: 1/23/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/27/2012 Req'd Qty: 1.00

1

Customer:

Reference: REWORK

DART				TEL: 1-613-632-3336	
TRANSPORT CANADA APPROVAL #09-89				FAX: 1-613-632-4443	
P/N	D206-667-201	CHG	CHG002		
DESC	Crosstube Aft High	STC	SH01-5		
LOT	B30440	STC	SR01304NY		
MODEL	Bell 206A/B	STC			

Approvals: Process Plan: *mf*

Date: *12-01-23* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

MADE IN CANADA

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D206-667-241	Rev C (DEO)
DSI 9471	Rev A

290

0.00

290

Crosstubes

Memo

0.00

Crosstubes

PULL FROM STOCK D206-667-201 B 30440

1) REMOVE SUPPORTS AND REWORK TO LATEST DRAWING
(*SUPPORTS ARE NOW INSTALLED USING PROSEAL INSTEAD OF
MAGNABOND)

2) REMOVE ABRASION STRIPS AND CLAMPS AND DISCARD

300

QC5- Inspect part completeness to step on W/O

0.00

300

QC

Memo

0.00

Quality Control

AS 12 - 1 - 20

12 - 01 - 26 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79210

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Page 2

Monday, January 23, 2012 3:26:16 PM

Item ID: D206-667-201

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Aft

Start Date: 1/23/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/27/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference: REWORK

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

310

0.00

310

Powdercoat
Powder Coating

Memo
SCUFF AND REPAINT TUBE IF NECESSARY

0.00

N/A

320

0.00

320

QC
Quality Control

QC3- Inspect Part Finish

Memo

0.00

N/A

330

0.00

330

Crosstubes
Crosstubes

Memo
RE-ASSEMBLE TUBE USING REWORKED SUPPORTS
ADD D3595-063-395 RUBBER CUSHION X 4
ADD MS210920-20 X 4

0.00

AP 12 - 1 - 30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 79210

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Page 3

Monday, January 23, 2012 3:26:16 PM

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N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Aft

Start Date: 1/23/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/27/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference: REWORK

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

340

QC5- Inspect part completeness to step on W/O

0.00

340

QC

Memo

0.00

Quality Control

12-01-31 (1)

350

350

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

Packaging

ID AND STOCK UNDER NEW BATCH NUMBER

NEW PAPERWORK + LABELS -

12-1-31 CHG004

360

360

QC

QC4- 100% Inspect kits for completeness

0.00

Memo

0.00

Quality Control

5/12/01

(1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 79210***79210***

Page 4

Monday, January 23, 2012 3:26:16 PM

Item ID: D206-667-201

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Crosstube Aft

Start Date: 1/23/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/27/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference: REWORK

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

370

QC21- Final Inspection - Work Order Release

0.00


370

QC

Memo

0.00

Quality Control

12/21/12 

R12-02-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Monday, January 23, 2012 3:26:16 PM

Page 1

Work Order ID: 79210

Parent Item: D206-667-201

Parent Item Name: Crosstube Aft

Start Date: 1/23/2012

Required Date: 1/27/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
615 DD VERF:EC

IPP REV:B 11.08.08 PER ECN 11-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3595-063-395 RUBBER CUSHION		Manufactured	No				Each	98.0000		4		AS 12-1-30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT052		98							
				70975		21							
				74300		77				4			
MS21920-20 Clamp (per MIL-DTL-8783C)		Purchased	No				Each	60.0000		4		AS 12-1-30	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				LG050		60							
				116799		10							
				119386		50				4			

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Item	Qty -241	Part Number	Description
1	X	D206-667-241	CROSSTUBE ASSEMBLY (206B HIGH AFT)
2	1	D6003-102	CROSSTUBE
3	2	D2891-1	SUPPORT
4	4	D3595-063-395	RUBBER CUSHION
5	4	MS21920-20	CLAMP (OR MS21920-21)
6	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

GENERAL NOTES:

- MATERIAL: MANUFACTURED FROM D6003-102
FINISHED LENGTH = 100.60±0.020
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- UNITS: INCHES UNLESS OTHERWISE NOTED.
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-241" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- WEIGHT: 22.5 lbs
- PART IS SYMMETRIC ABOUT CENTERLINE.
- RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS MECHANISMS ARE LOCATED ON CROSSTUBE CLAMPS.
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

UNDER REVIEW

RELEASED
08/11/12

DEO ATTACHED

C	REFORMAT/REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCES (ZN C5-3, C4-3, D3-3); RELOCATED FLAG #6 (ZN A7-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	PH	05.02.04
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. C
CHECKED	RF	D206-667-241	SHEET 1 OF 4
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	CROSSTUBE ASSY (206B HIGH AFT)	NTS
DE APPR.	RF	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	08.11.06		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

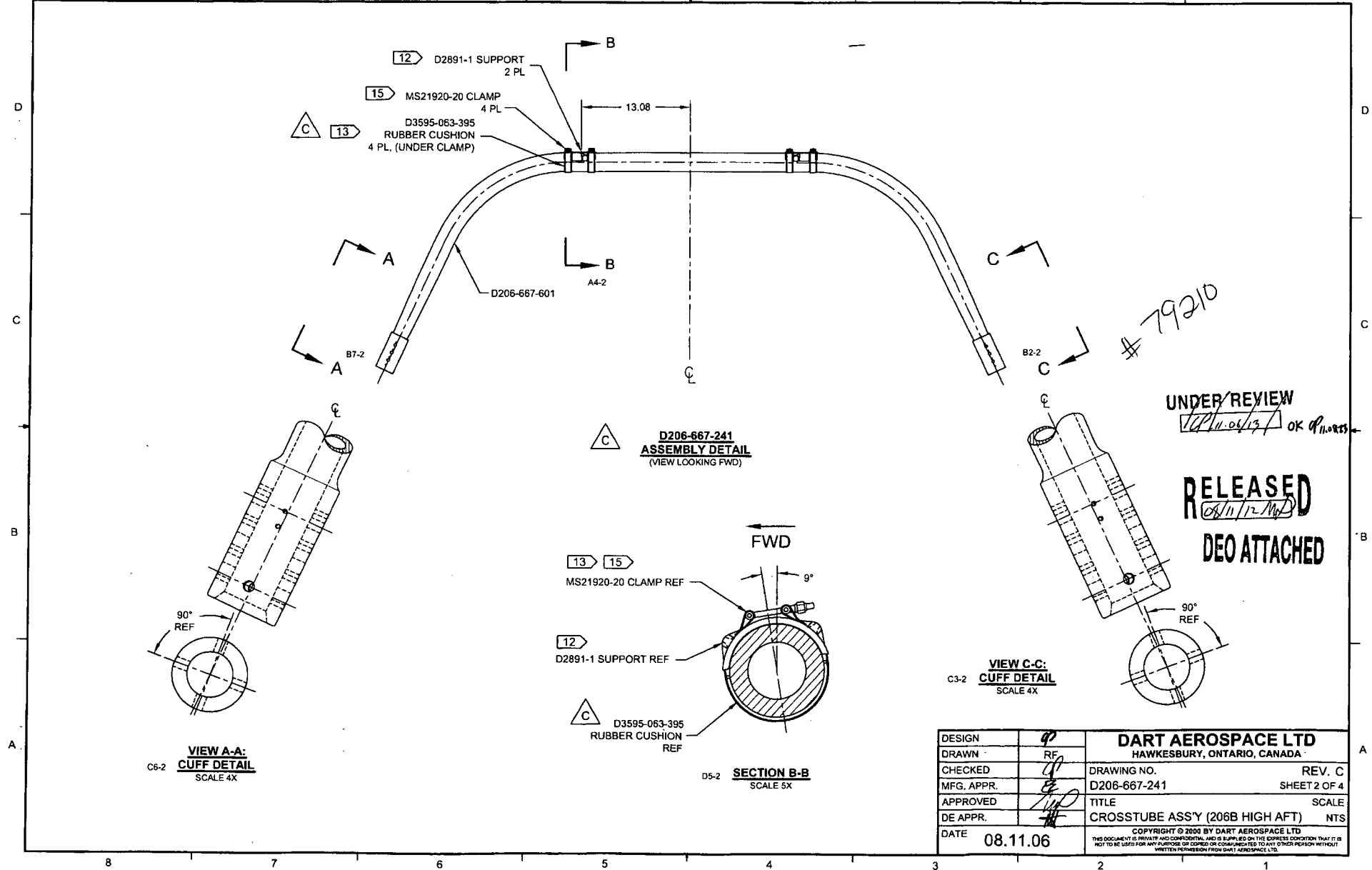
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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8 7 6 5 4 3 2 1



DESIGN	9	DART AEROSPACE LTD	
DRAWN	RE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	9	DRAWING NO.	REV. C
MFG. APPR.	9	D206-667-241	SHEET 2 OF 4
APPROVED	9	TITLE	SCALE
DE APPR.	9	CROSSTUBE ASS'Y (206B HIGH AFT)	NTS
DATE	08.11.06	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Dart Aerospace Ltd

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NOTE: Date & initial all entries

8

7

6

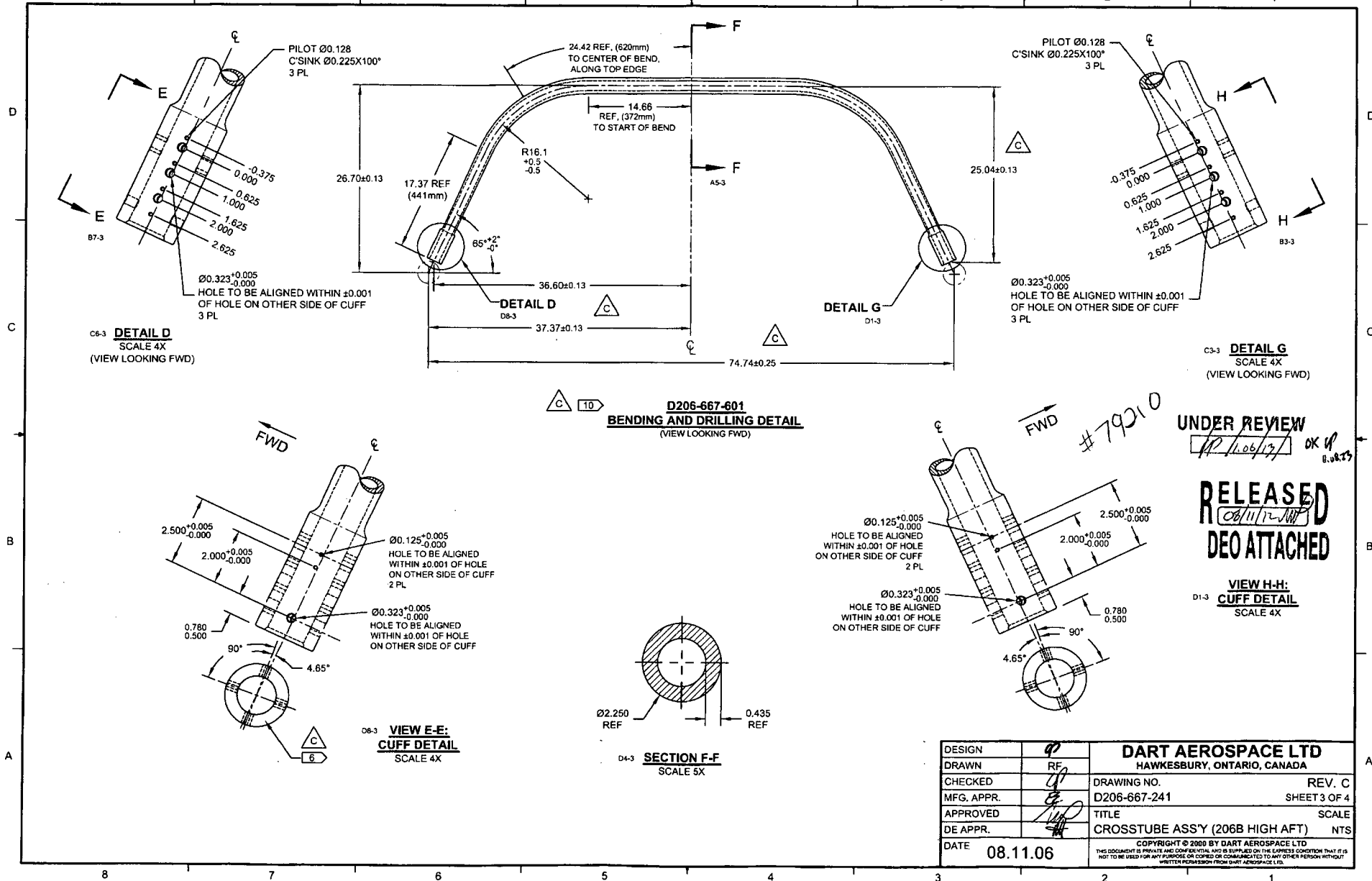
5

4

3

2

1



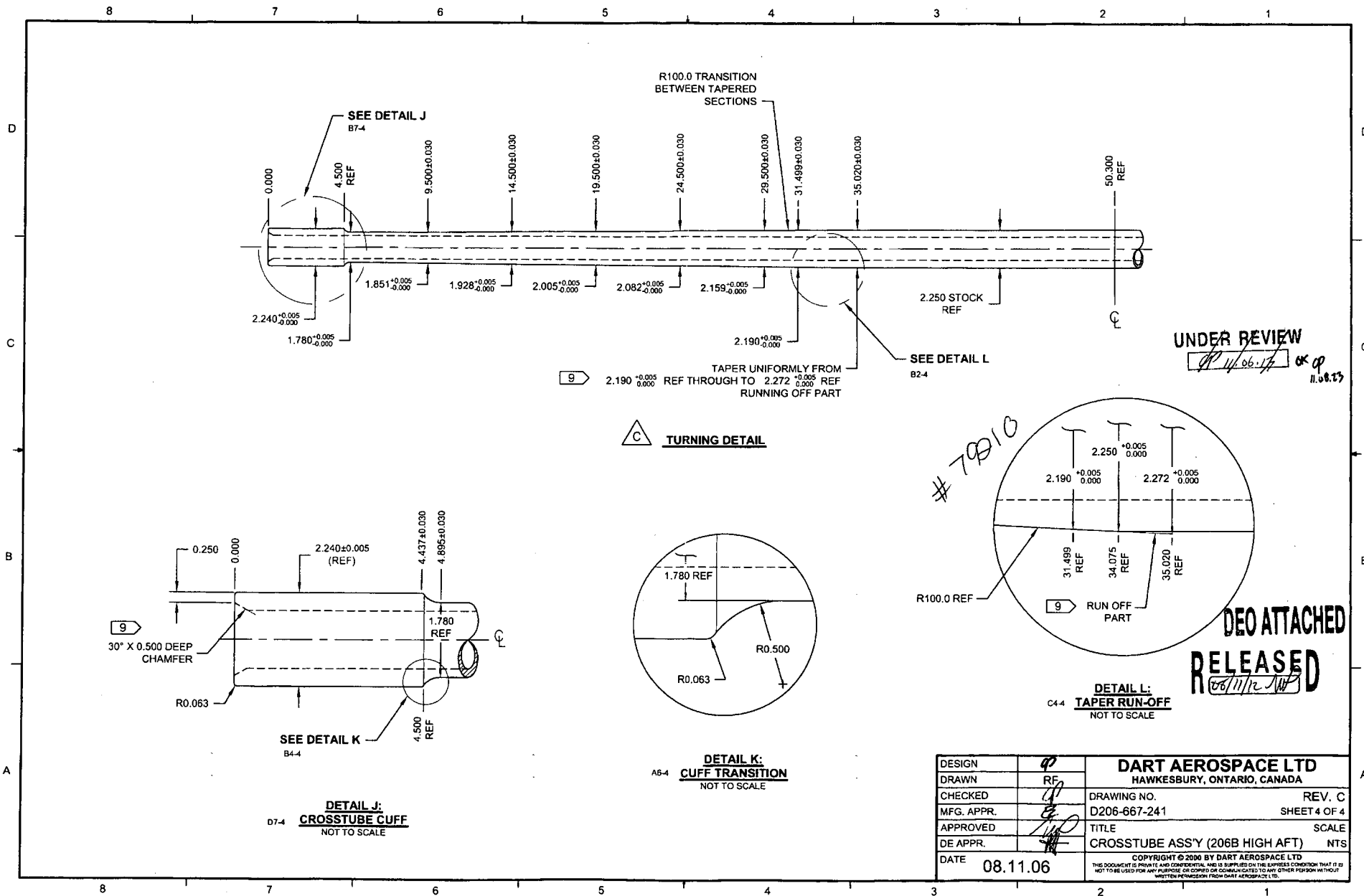
W/O:		WORK ORDER CHANGES					
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DRAWING NO. ~ D206-667-241	TITLE CROSSTUBE ASS'Y (206B HIGH AFT)	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D206-667-241-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>q</i>	CHECKED <i>AS</i>	MFG. APPR. <i>M</i>	APPROVED <i>MD</i>		DE APPR. <i>HA</i>		
DATE 11.07.15	DATE 11.08.22	DATE 11.08.22	DATE 11/08/22		DATE 11.08.22		

PURPOSE:

REPLACE MAGNOBOND WITH PROSEAL.

CHANGE:

IS:

Item	Qty -241	Part Number	Description
6	A/R	PROSEAL 890 B-2	SEALANT, AMS-S-8802 CLASS B-2

WAS:

6	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)
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NOTE 12 & 15, SHEET 1 IS AMENDED AS FOLLOWS:

IS:

- 12) TO INSTALL D2891-1 SUPPORT: ABRABE MATING SURFACE OF SUPPORT AND CROSSTUBE WITH 180-GRIT SANDPAPER AND REMOVE RESIDUE WITH MEK (OR EQUIVALENT). APPLY A 0.04" TO 0.07" THICK LAYER OF PROSEAL 890 CLASS B-2 (OR AMS-S-8802 CLASS B-2) SEALANT TO MATING SURFACE OF SUPPORT.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING. **PRIOR TO PACKAGING, RE-CHECK TORQUE ON CLAMPS AFTER PROSEAL 890 SEALANT HAS CURED FOR 72 HOURS.**

WAS:

- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

+79210

RELEASED
2011-08-23
MD

W/O:		WORK ORDER CHANGES					
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DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-667 REV. C OR EARLIER REVISION
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-667 REV. 2 OR EARLIER REVISION

REF TCCA STC: SH01-5
REF FAA STC: SR01304NY
REF EASA STC EASA.IM.R.S.01179

PURPOSE:

For the D206-667-201 Crosstube Installation, the parts list was missing the required drill bit specified in Figure 5 of IIN-D206-667 and Figure 32-5 of ICA-D206-667.

CHANGE:




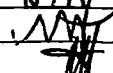
For the D206-667-201 Crosstube Installation, the included D3039-3 Center Drill is used to open the specified holes to Ø0.313". The hole must then be opened to Ø0.323"+0.005/-0.000. The parts list of IIN-D206-667 and ICA-D206-667 is amended as follows:

5.0 PARTS LIST (IIN-D206-667 REV. C OR EARLIER REVISION)
32.8 PARTS LIST (ICA-D206-667 REV. 2 OR EARLIER REVISION)

QTY	PART NUMBER	DESCRIPTION
-201		
X	D206-667-201	CROSSTUBE INSTALLATION, 206A/B HIGH AFT
1	D3039-3	CENTER DRILL (ADD)

#79210

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY:	
D. SHEPHERD (DE # 02)	
DATE:	09.07.06
CERT. NO.:	SH01-5
ISSUE NO.:	3

A	NEW ISSUE, NCR 09-005	CP	09.07.06
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9471	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		CENTER DRILL ADDITION	NTS
DATE	09.07.06	COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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